

Polyvinyl chloride (PVC) has been used for a long time for manufacturing sheet multilayer products intended for making carpets or wall claddings or trims for vehicle passenger compartments. However, considerations related to the protection of the environment argue for replacement of polyvinyl chloride with chlorine-free polymers or copolymers. Quite naturally, the selection was directed towards olefinic polymers and copolymers, especially polymers and copolymers of ethylene and propylene, given their relatively low price cost and their good chemical and thermal properties.

A disadvantage of olefinic polymers in such applications lies in the difficulties encountered upon doubling the individual layers in order to form a multilayer product. Indeed, olefinic products badly lend themselves to rolling as the products tend to adhere to the rolling cylinders.

The technique conventionally used in PVC floorings, i.e., a coating followed by gelation is not feasible in the case of olefinic and/or ionomer products.

The invention is directed to creating a new technique for doubling sheets in order to obtain a multilayer product having sufficient adherence between the layers which make it up and a high quality surface aspect.

Accordingly, the invention relates to a method for manufacturing multilayer products comprising, on a polymeric substrate, at least one wear thermoplastic polymer layer. The method is characterized by the following steps:

- preheating the backing, preferably at a temperature between 100 and 130°C,
- cold application of the wear layer on the preheated backing,
- ~~contacting the backing with the wear layer,~~
- melting the wear layer on the backing, to ensure that it adheres with the backing, preferably at a temperature between 120°C and